

Work Order ID 50036

July 6, 2009 9:48:48 AM



Page 1

Item ID: D2252-11

Accept



Setup Start



Revision ID: G

Stop



Item Name: Frame

Start Date: 7/06/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/10/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D2252	G

100



Large Fab

Memo

0.00

Large Fab

1- Cut as per dwg D2252
2- Deburr and remove identification markings on tube

SAD 09-07-14 (2)

110



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

0.00

Quality Control

09/07/14

(2)

F

120



Identify as per dwg & Stock Location: WA

0.00

Packaging

Memo

0.00

Packaging

SAD 09-07-15 (x2)

Work Order ID 50036

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Page 2

Item ID: D2252-11

Accept



Setup

Start



Revision ID: G

Stop



Item Name: Frame

Start Date: 7/06/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/10/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

130



QC

Quality Control

**Operation
Description**

QC21- Final Inspection - Work Order Release

**Set Up/
Run Hours**

0.00

**Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

09/07/10 AF

MF
09-07-15

Memo

0.00

Picklist Print

July 6, 2009 9:48:47 AM

Page 1

Work Order ID: 50036



Parent Item: D2252-11RevG



Parent Item Name: Frame

Start Date: 7/06/09

Required Date: 7/10/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	680.8900	4.3789			

304 SQ Tube .75x.75x.065W



Warehouse

Location

Main Warehouse

MAT	680.89	
110969	3.29	
111148	15.96	
111331	1.96	
111432	0.44	
111885	25.14	
112051	634.1	

Loc Qty

Loc Code

4.3789

1.0 Sq End Bar Scrap

SAM 09-07-14

Qty
2

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3	X		D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

G

G

G

G

G

50036

RELEASED
09/04/18 PM

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. REV. G	
CHECKED		D2252 SHEET 1 OF 6	
MFG. APPR.		TITLE SCALE	
APPROVED		DE APPR. NTS	
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE THAN THAT FOR WHICH IT WAS PROVIDED OR FOR ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.	

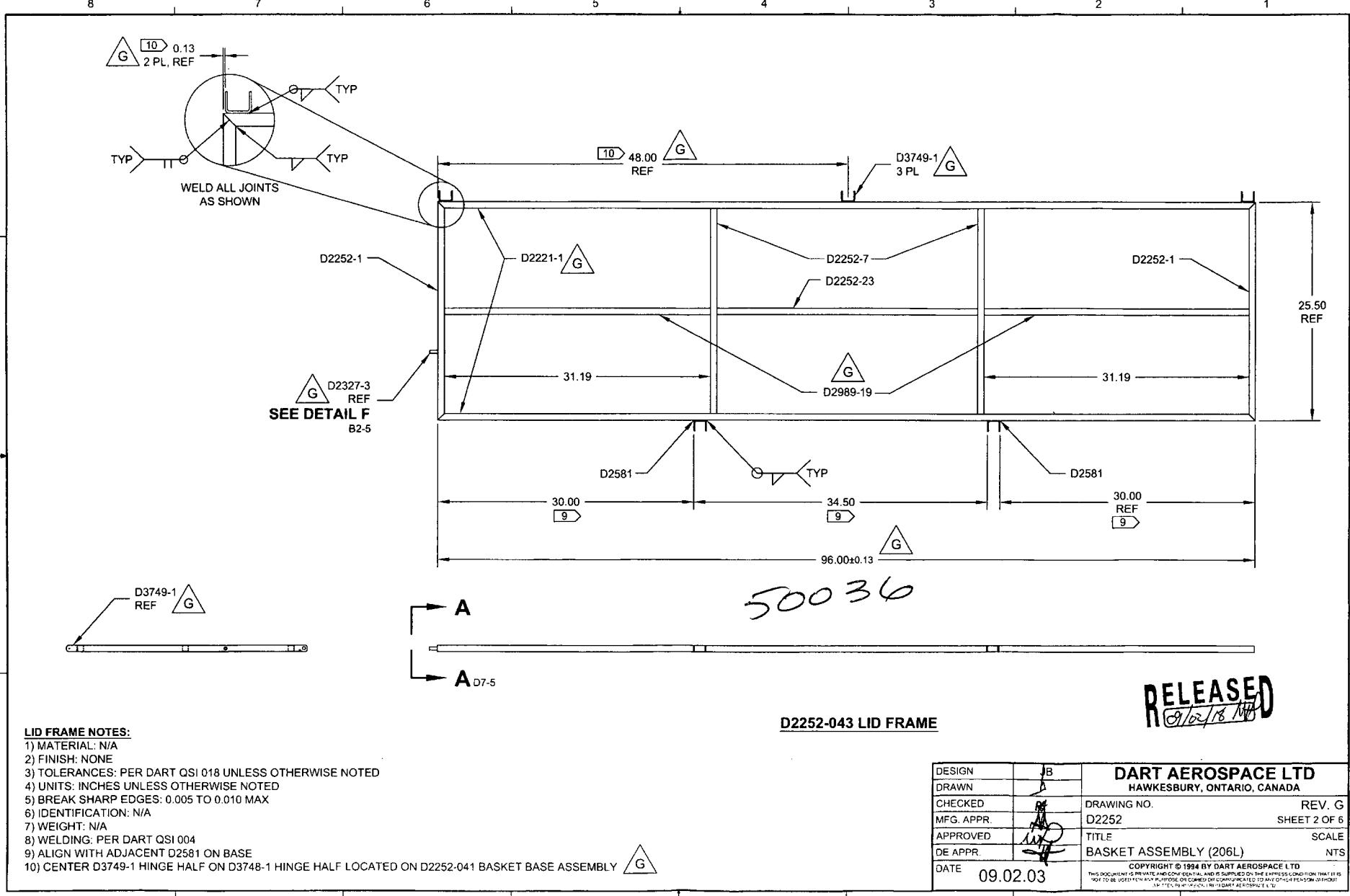
8 7 6 5 4 3 2 1

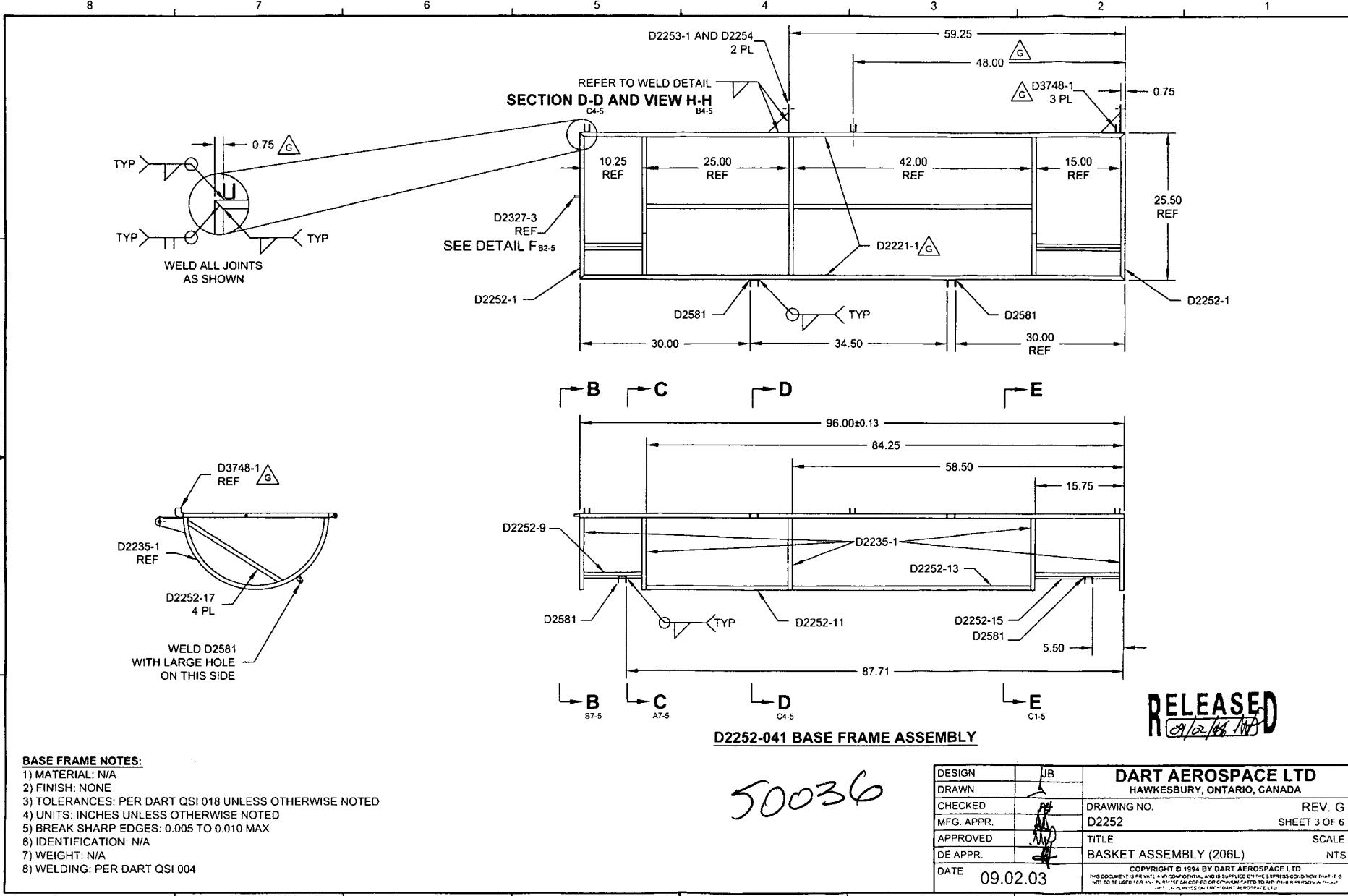
D

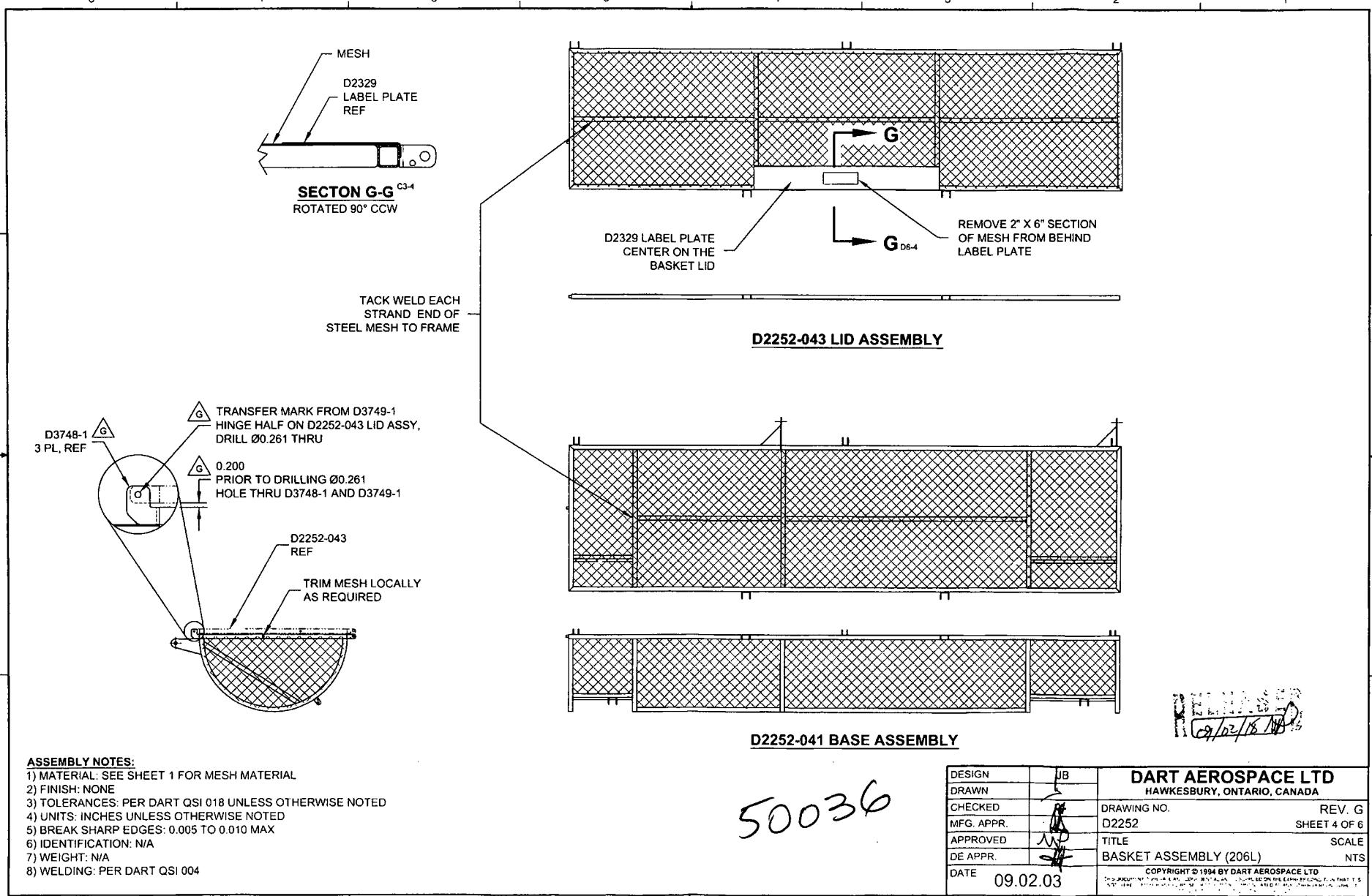
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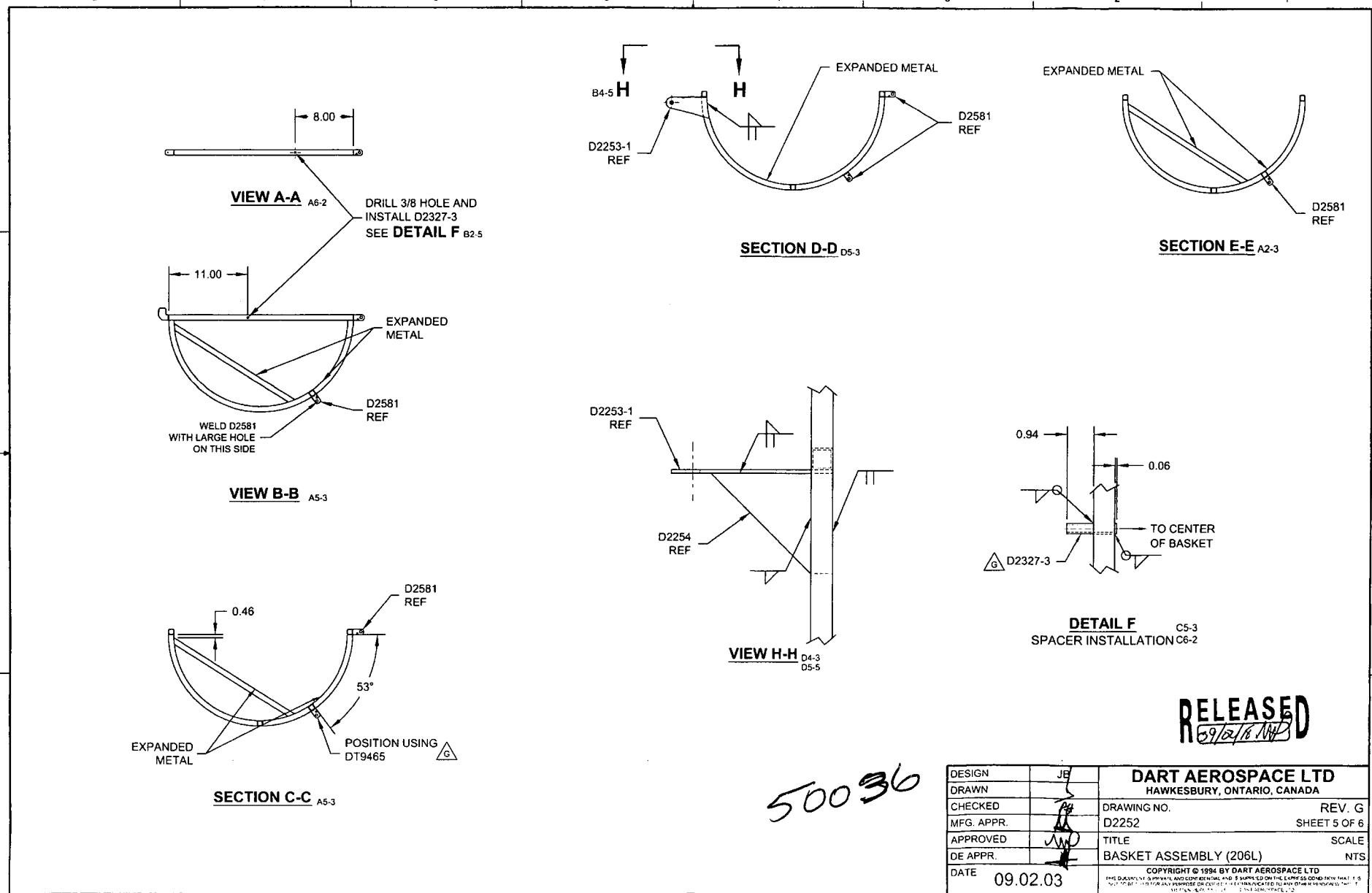
B

A









8 7 6 5 4 3 2 1

D

D

C

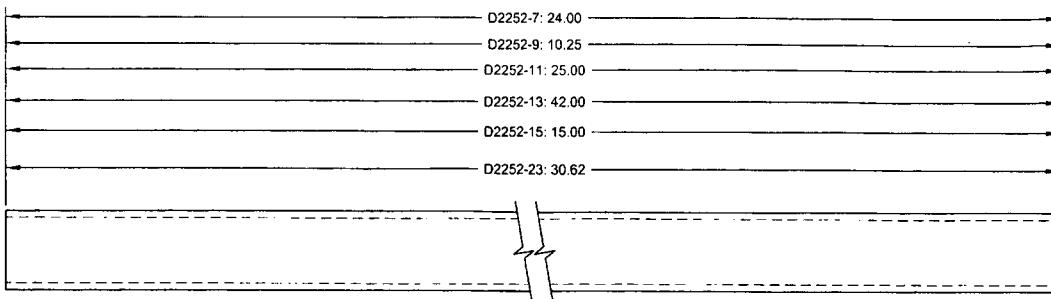
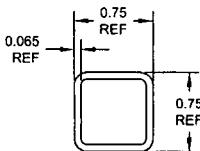
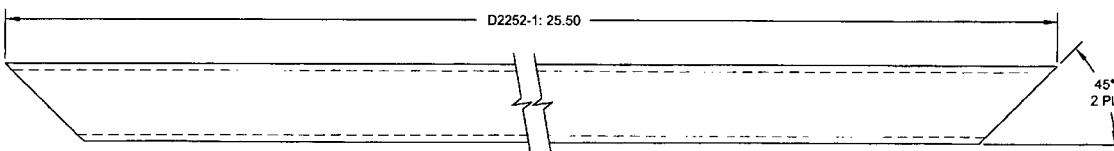
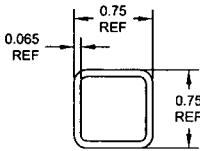
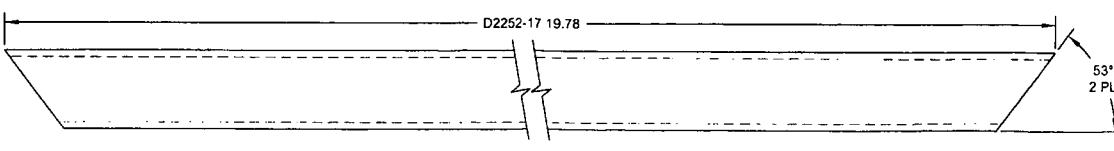
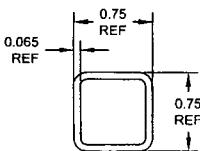
C

B

B

A

A

**D2252-7 FRAME****D2252-9 FRAME****D2252-11 FRAME****D2252-13 FRAME****D2252-15 FRAME****D2252-23 FRAME****D2252-1 FRAME****D2252-17 FRAME**

50036

RELEASED
07/02/06 JWP

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. G
MFG. APPR.		DRAWING NO.
APPROVED		D2252
DE APPR.		SHEET 6 OF 6
		TITLE
		SCALE
		BASKET ASSEMBLY (206L)
DATE	09.02.03	NTS

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